

Date: Friday, 5/25/2007 8:16:25 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 L WEB
Job Number : 32578	
Estimate Number : 10722	
P.O. Number : N/A	Part Number : D26547
This Issue : 5/25/2007 S.O. No. : N/A	Drawing Number : D2654 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E1
Previous Run : 32468	Material : N/A
Written By : _____	Due Date : 5/31/2007 Qty: 5 Um: Each
Checked & Approved By : <u>07.05.28</u>	
Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedure DM	
Est Rev:e 06.04.05 Added level21 EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26007125 Extrusion 'I Beam' thick



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-7- 125	Web	B 21130

Jb 7-6-4

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

Jb 7-6-4

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-04 (6)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Jb 7-6-5

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/18/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:16:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 32578

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-6-5

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

DP

7-6-5

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)

206 L WEB

Job Completion



U 57-06-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

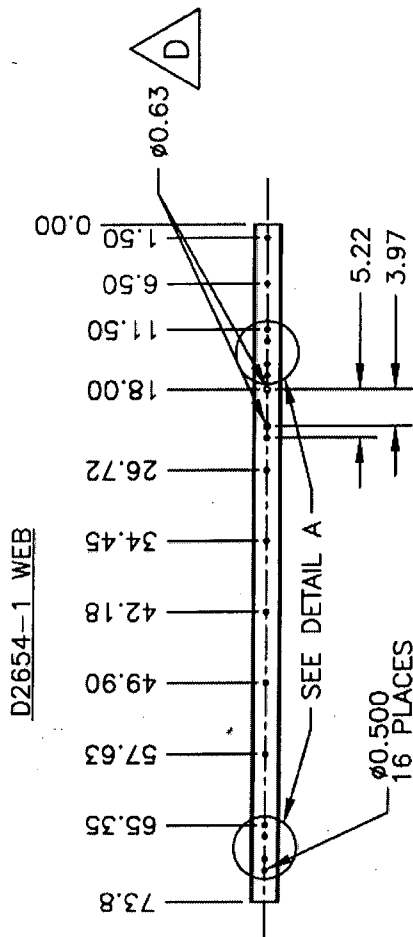
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

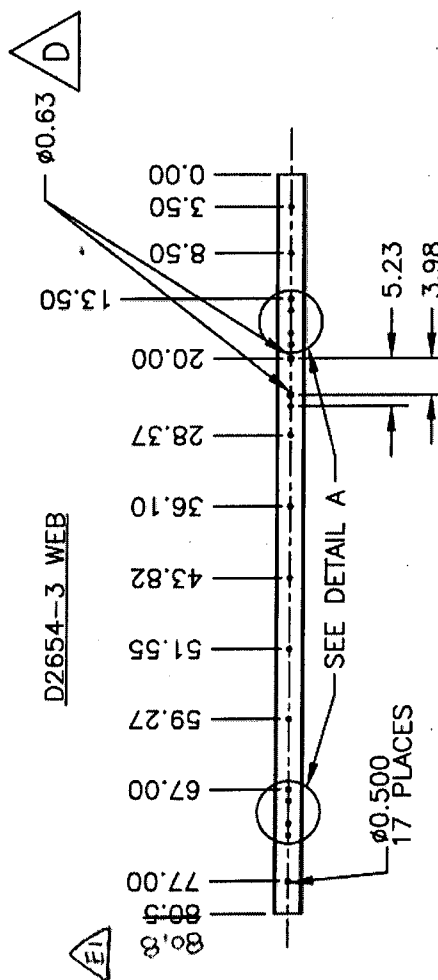
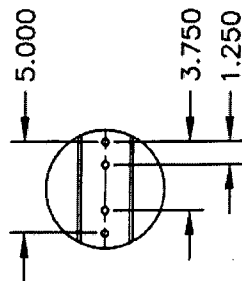


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D2654
				REV. E SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE 1:20
A	---	97.03.25	NEW ISSUE	
B		97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C		97.10.29	CHANGED HOLE PATTERN	
D		98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E		04.05.26	CHANGE LENGTHS, REFORMAT	
E1	CP	04.08.04	PER TOOLING; 80.8 WAS 80.5	

RELEASED  
04.06.22



DETAIL A  
SCALE 1:10



MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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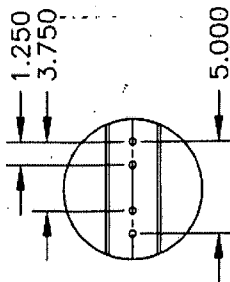




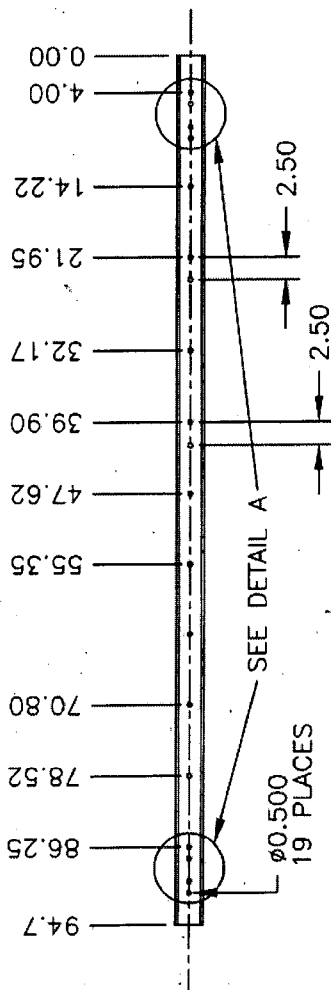
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED  
04.06.22

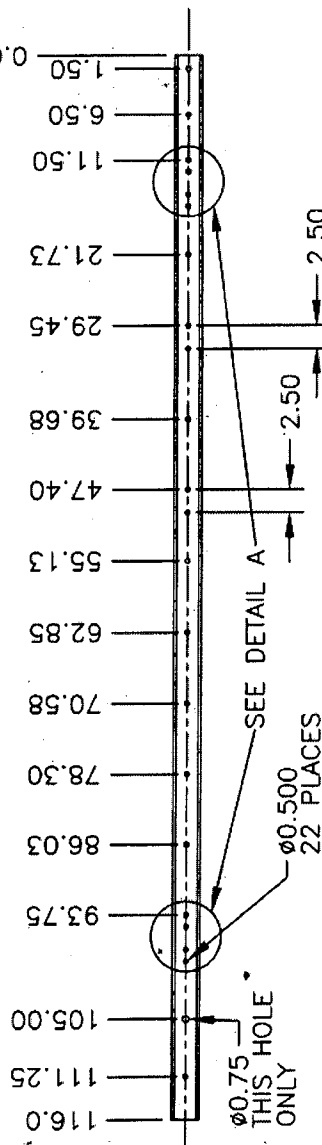
DETAIL A  
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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